

Date: Friday, 01/08/2008 3:32:40 PM  
User: Julie Lecocq

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 40980-1  
Estimate Number : 13333  
P.O. Number :  
This Issue : 01/08/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : SMALL / MED FAB  
Previous Run : 05004

Drawing Name : HEADREST ADAPTER

Part Number : D3773041  
Drawing Number : D3773 REVB  
Project Number :  
Drawing Revision : B  
Material :  
Due Date : 21/08/2008

Written By :

Checked &amp; Approved By :

Comment :

Est Rev:A 08-05-21 new issue DD verified by:ec  
Est Rev:B 08-07-18 revB as per dwg DD verified by:EC

Qty: 8 Split 32 Um: Each

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

2.0

D37731

Adapter



Comment: Qty.: 1.0000 Each(s)/Unit Total : 32.0000 Each(s)

Adapter

batch: B40484

Pl 08-08-08

3.0

D37733

Leg



Comment: Qty.: 1.0000 Each(s)/Unit Total : 32.0000 Each(s)

Leg

batch: 40657

mf 08-08-07

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- locate top hole with a 3/16" dowel pin and tack weld D3773-1 adapter to D3773-3 leg as per dwg D3773  
\*\*\*\*take dowel pin out before welding\*\*\*\*

2- weld as per dwg D3773 QSI004

304 S.S. Welding Rod Batch: M106762

3- if necessary grind interior of D3773-3 leg flush after welding

Pl 08-08-08



## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: HEADREST ADAPTER

Job Number: 40980

Part Number: D3773041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/08 (x8)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-08 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 118

DS 08/08/08 x8

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8  
08/08/11

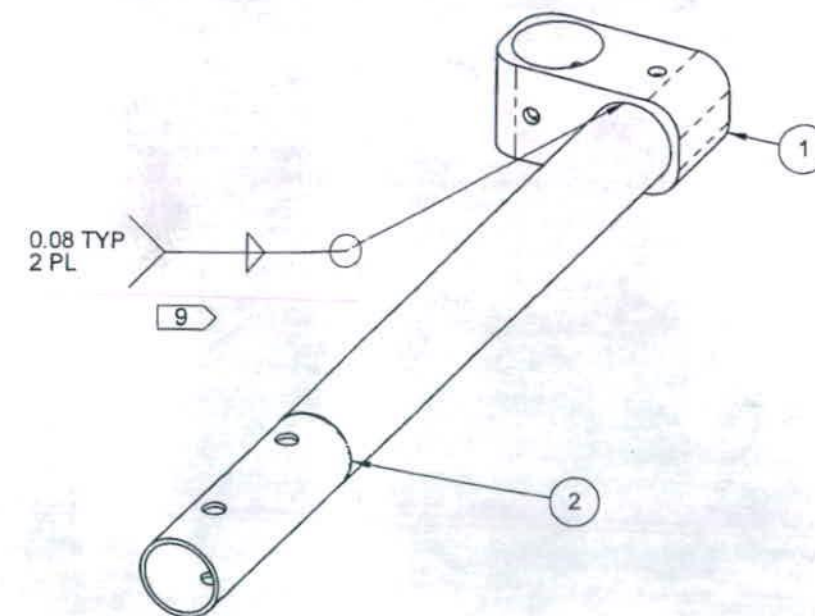
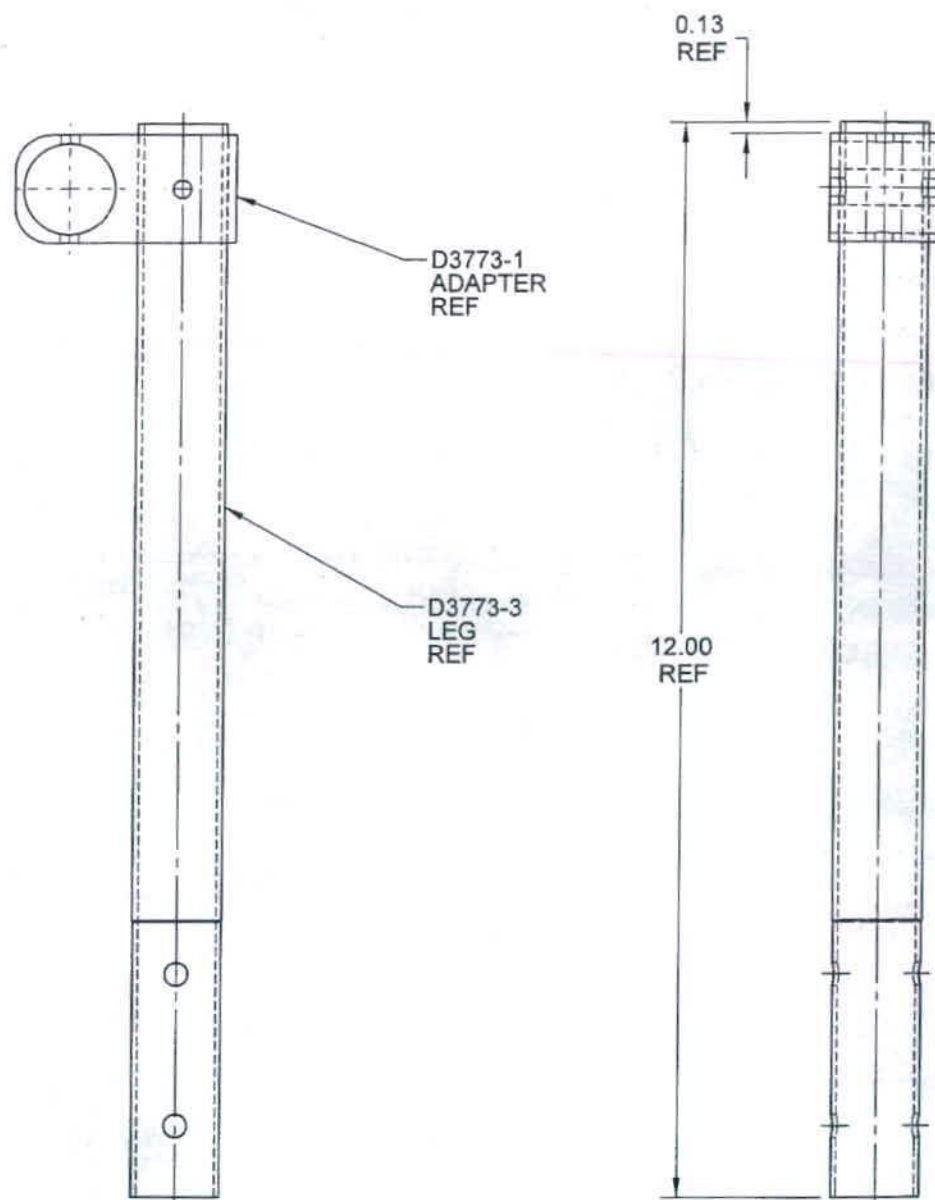
Job Completion



MF 08-08-11







ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

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NO. 40980

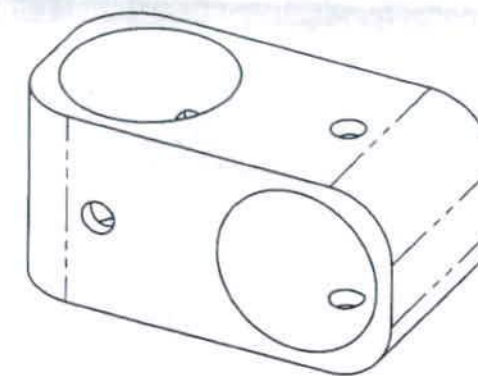
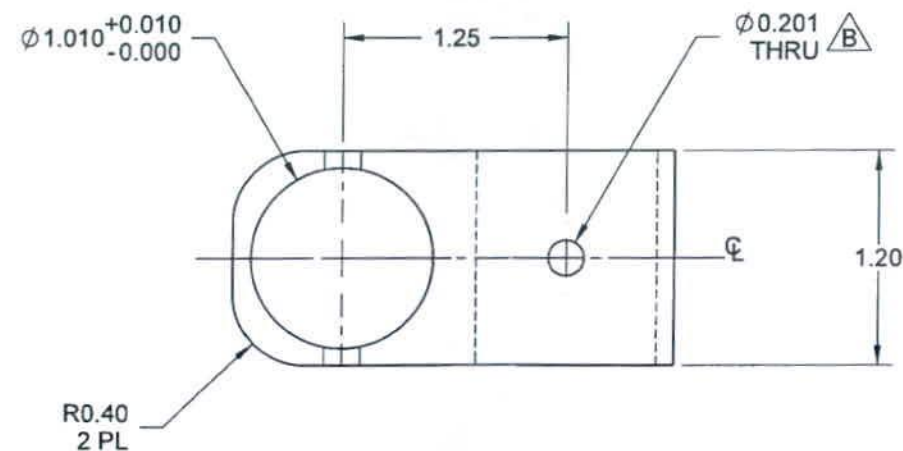
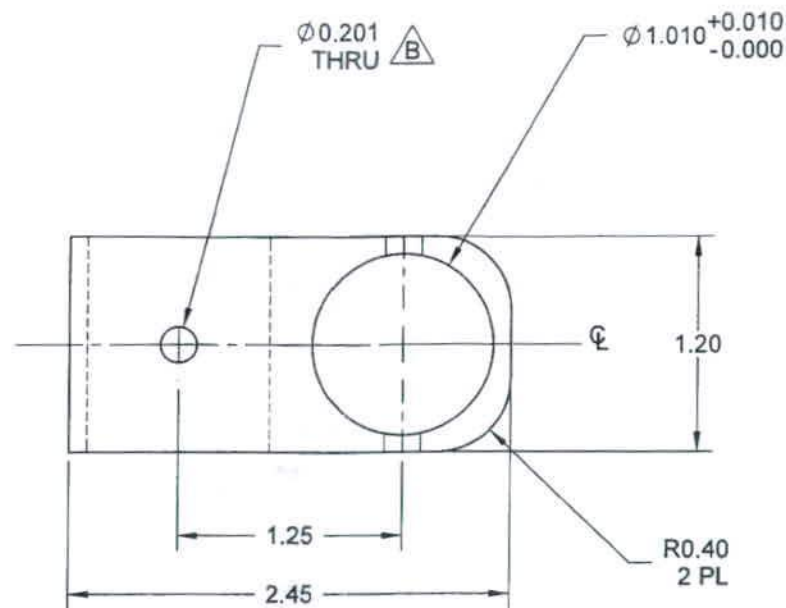
#### NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs  
D3773-3, 0.69 lbs  
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

#### D3773-041 HEADREST ASSEMBLY

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3773	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	HEADREST ADAPTER	NTS
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**D3773-1 ADAPTER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

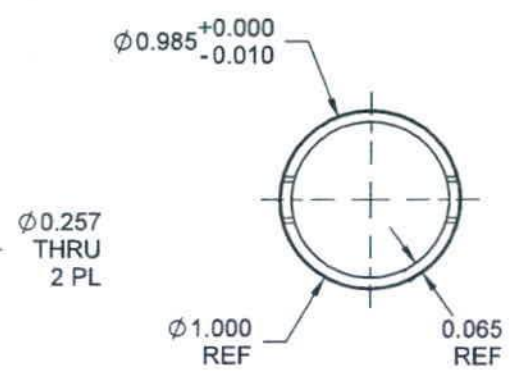
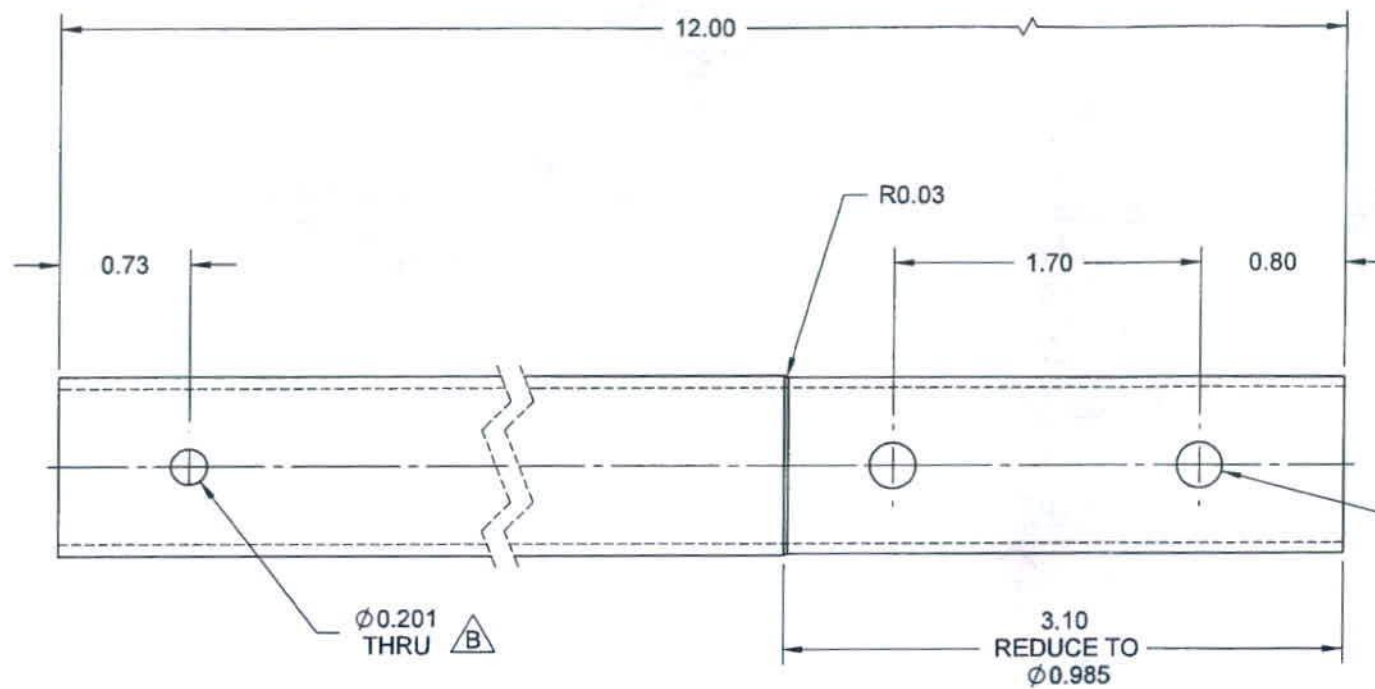
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**D3773-3 LEG**

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.69 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
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RELEASED  
08.07.10 MJD

